

Date: Friday, 8/31/2007 11:53:40 AM
 User: Kim Johnston

Process Sheet

| | |
|---|-------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : DOOR - |
| Job Number : 34380 | |
| Estimate Number : 12266 | |
| P.O. Number : <i>N/A</i> | Part Number : D3140106 |
| This Issue : 8/31/2007 S.O. No. : <i>N/A</i> | Drawing Number : D3140 REV F |
| Prsht Rev. : NC | Project Number : <i>N/A</i> |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision : <i>F</i> |
| Previous Run : 27344 | Material : <i>SA</i> |
| Written By : <i>[Signature]</i> | Due Date : 9/4/2007 Qty: 6 Um: Each |
| Checked & Approved By : <i>[Signature] 07.08.31</i> | |
| Comment : Est Rev: A New Issue 06-02-08 JLM | |
| Est. Rev B New dwg rev. ecn781 06.04.18 EC | |
| Est. rev.C added scuffing NCR 061 EC | |
| Est Rev:D As per ECN #829 06-11-20 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S032 | 2024-T3 .032 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0578 sf(s)/Unit Total : 0.3465 sf(s)
 2024-T3 .032 " Thick sheet
 (M2024T3S032)
 Batch: *M100284 IB 07-09-02*

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



*PROG
Dwg*

E F

IB 07-09-02



Comment: SHEAR
 Cut Blanks 2.45" x 3.13 as per Dwg D3140

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Cut Angle as per Dwg D3140

N/A

SRS 07/09/10

| | | |
|-----|----------|----------|
| 4.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Form as per Dwg D3140

SRS 07/09/10

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/18/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 8/31/2007 11:53:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR -

Job Number: 34380

Part Number: D3140106

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr.

No sharp edges

SB 07/09/10

(6)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

cautis
SA 07/10/10

(6)

7.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W 07-09-11

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/09/11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51177

SB 07/09/11

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/09/11

Job Completion



W 07-09-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------------|--|------------------------|
| DESIGN # | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED JH | APPROVED # | DRAWING NO. D3140 | REV. F SHEET 1 OF 7 |
| DATE 06.10.06 | | TITLE DOOR | SCALE NTS |
| A | 02.04.18 | NEW ISSUE | |
| B | 03.01.23 | REMOVE -65/-81/-83; ADD -301/-303 | |
| C | 04.11.08 | CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106° | |
| D | 05.11.23 | ADD -103/-104/-105/-106; REMOVE -67 | |
| E | 06.06.09 | 1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10 | |
| F | 06.10.06 | ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE | |

RELEASED

06.11.13

| QTY -05 | QTY -06 | QTY -07 | QTY -08 | QTY -09 | QTY -10 | PART NUMBER | DESCRIPTION |
|------------|------------|------------|------------|------------|------------|--------------|------------------|
| X | | | | | | D3140-05 | DOOR |
| | X | | | | | D3140-06 | DOOR |
| | | X | | | | D3140-07 | DOOR |
| | | | X | | | D3140-08 | DOOR |
| | | 1 | | X | | D3140-09 | DOUBLER ASSEMBLY |
| | | | 1 | | X | D3140-10 | DOUBLER ASSEMBLY |
| 3 | 3 | | | | | D3140-57 | PAD |
| 1 | 1 | | | | | D3140-59 | PAD |
| 2 | 2 | | | | | D3140-61 | PAD |
| 2 | 2 | | | | | D3140-63 | PAD |
| | | 1 | 1 | | | D3140-69 | PAD |
| | | 1 | 1 | | | D3140-71 | PAD |
| | | 1 | 1 | | | D3140-73 | PAD |
| | | 1 | 1 | | | D3140-75 | PAD |
| | | 1 | 1 | | | D3140-77 | PAD |
| | | 1 | 1 | | | D3140-79 | PAD |
| | | | | 1 | 1 | D3140-85 | ANGLE |
| 1 | 1 | | | | | D3140-87 | DOUBLER |
| | | | | 1 | 1 | D3140-89 | DOUBLER |
| | | 1 | | | | D3140-91 | DOUBLER |
| | | | 1 | | | D3140-92 | DOUBLER |
| 3 | 3 | | | | | D3140-95 | DOUBLER |
| 1 | | | | | | D3140-97 | DOUBLER |
| | 1 | | | | | D3140-98 | DOUBLER |
| | | 1 | 1 | | | D3140-99 | DOUBLER |
| | | 2 | 2 | | | D3140-101 | DOUBLER |
| | | 1 | | | | D3140-103 | DOUBLER |
| | | | 1 | | | D3140-104 | DOUBLER |
| | | 1 | | | | D3140-105 | DOUBLER |
| | | | 1 | | | D3140-106 | DOUBLER |
| 1 | 1 | | | | | D3140-241 | DOUBLER |
| 1 | | 1 | | | | D3140-301 | DOUBLER |
| | 1 | | 1 | | | D3140-303 | DOUBLER |
| | | | | 5 | 5 | MS20426AD3-4 | RIVET |

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| CHECKED JH | APPROVED # | DRAWING NO. D3140 | REV. F SHEET 2 OF 7 |
| DATE 06.10.06 | | TITLE DOOR | SCALE NTS |

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

| PART | TOOL |
|-----------|---------------|
| D3140-05 | B30-23000-01T |
| D3140-06 | B30-23000-02T |
| D3140-07 | B30-23000-03T |
| D3140-08 | B30-23000-04T |
| D3140-57 | B30-23000-57T |
| D3140-61 | B30-23000-61T |
| D3140-63 | B30-23000-63T |
| D3140-69 | B30-23000-69T |
| D3140-71 | B30-23000-71T |
| D3140-73 | B30-23000-73T |
| D3140-75 | B30-23000-75T |
| D3140-77 | B30-23000-77T |
| D3140-79 | B30-23000-79T |
| D3140-89 | D3140-89T1 |
| D3140-301 | D3140-301T1 |
| D3140-303 | D3140-303T1 |

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

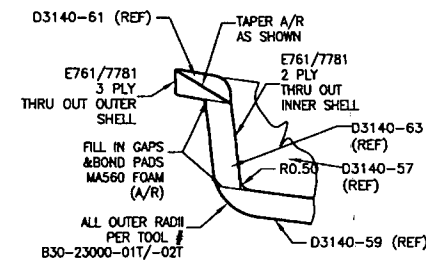
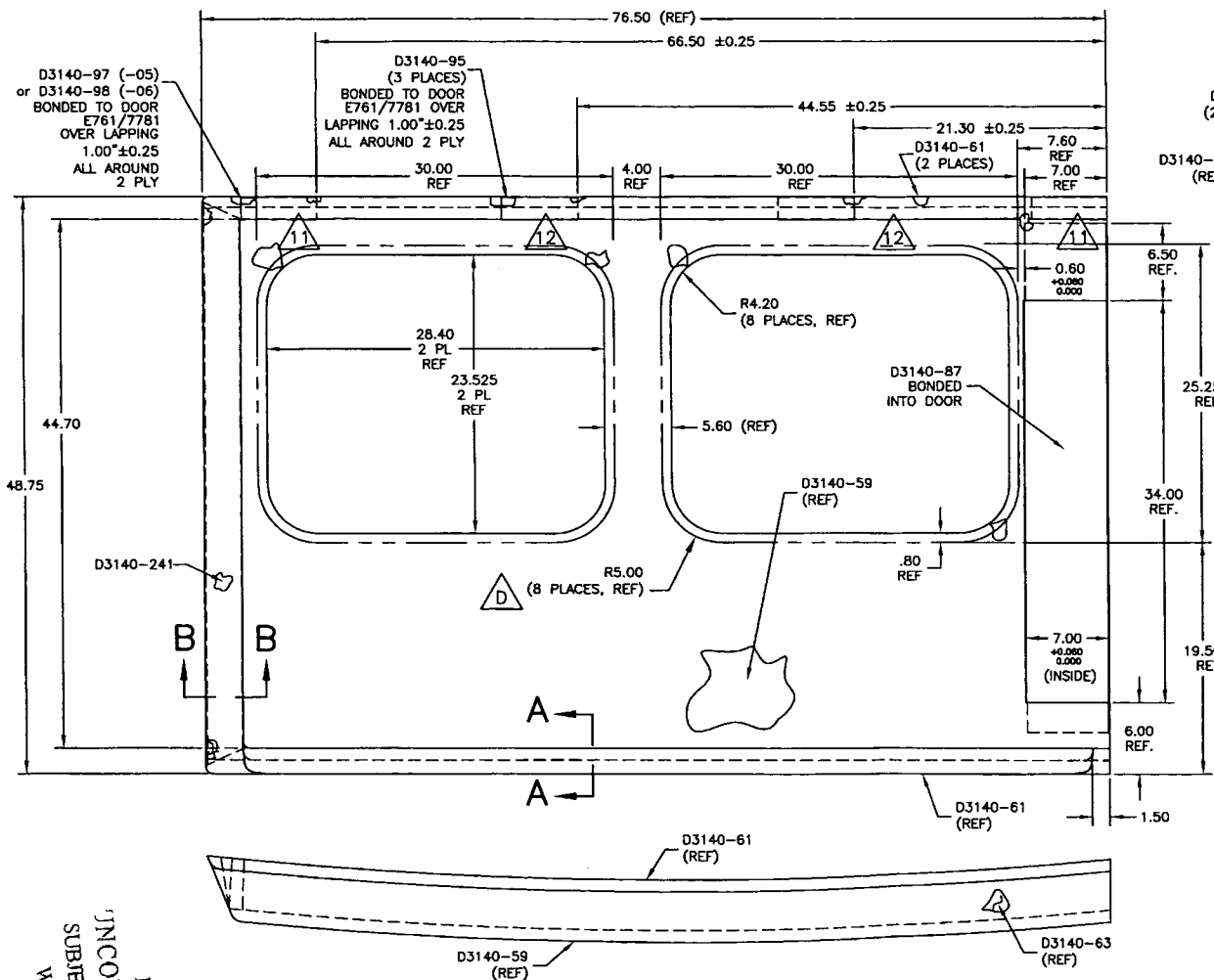
PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1

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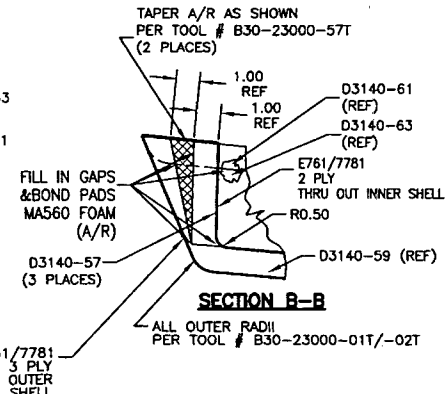
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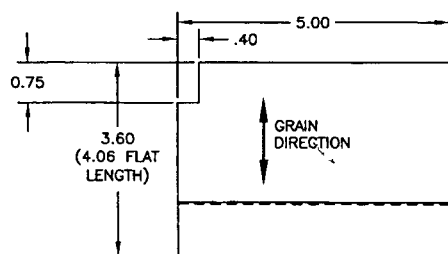
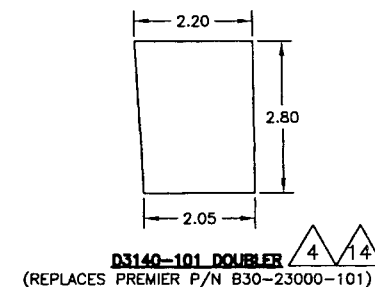
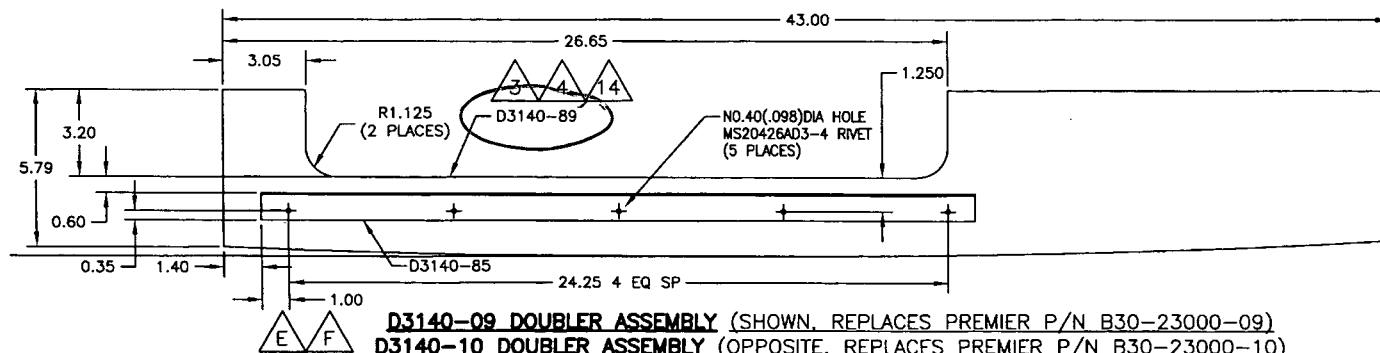


D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-08 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-08)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

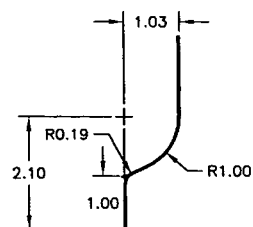


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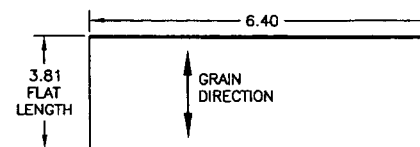
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| | | DATE 06.10.06 | | TITLE DOOR | SCALE NTS |



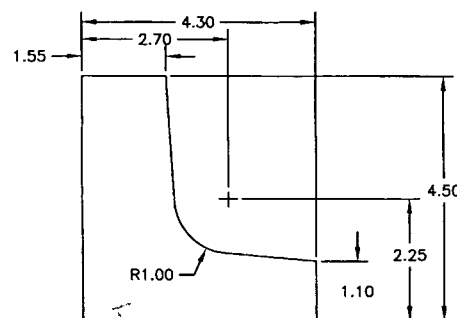
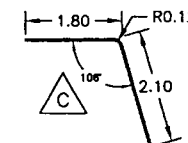
D3140-91F FLAT PATTERN
(USE TO MAKE D3140-91/-92 DOUBLERS)



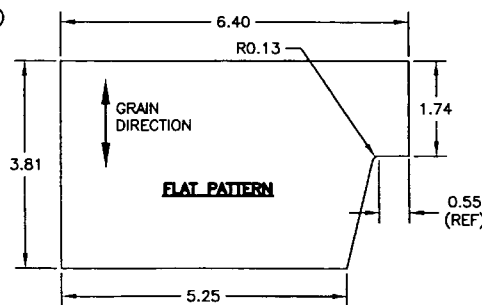
D3140-92 DOUBLER
(SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



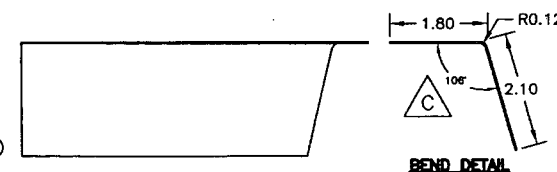
D3140-95 DOUBLER
(REPLACES PREMIER P/N B30-23000-95)



D3140-99 DOUBLER
(REPLACES PREMIER P/N B30-23000-99)



D3140-97F FLAT PATTERN
(USE TO MAKE D3140-97/-98 DOUBLERS)



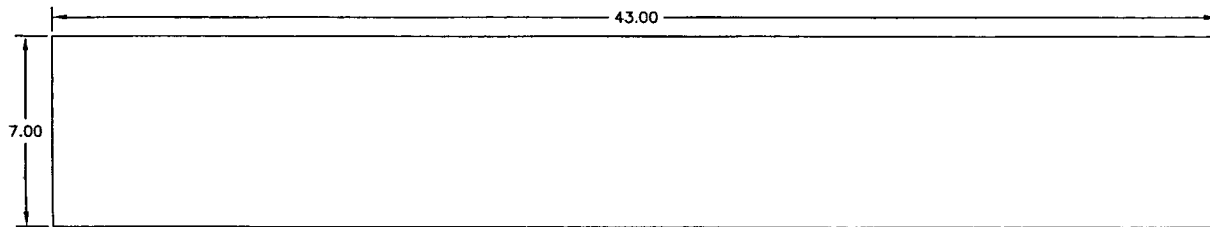
D3140-97 DOUBLER
(SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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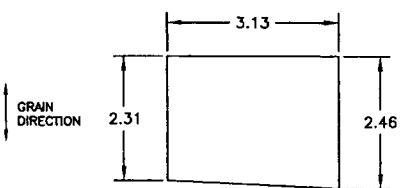
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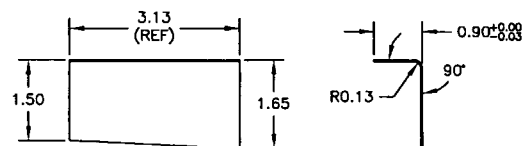
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| CHECKED JLH | APPROVED JLH | DRAWING NO. D3140 | REV. F SHEET 5 OF 7 |
| DATE 06.10.06 | TITLE DOOR | SCALE NTS | |



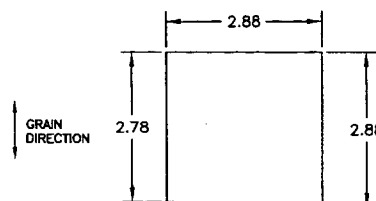
D3140-87 DOUBLER $\triangle 4 \triangle 14$
(REPLACES PREMIER P/N B30-23000-87)



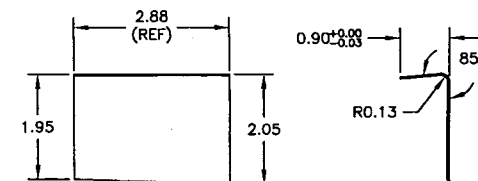
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



D3140-105 DOUBLER $\triangle 4 \triangle 14 \triangle D$
D3140-106 OPPOSITE

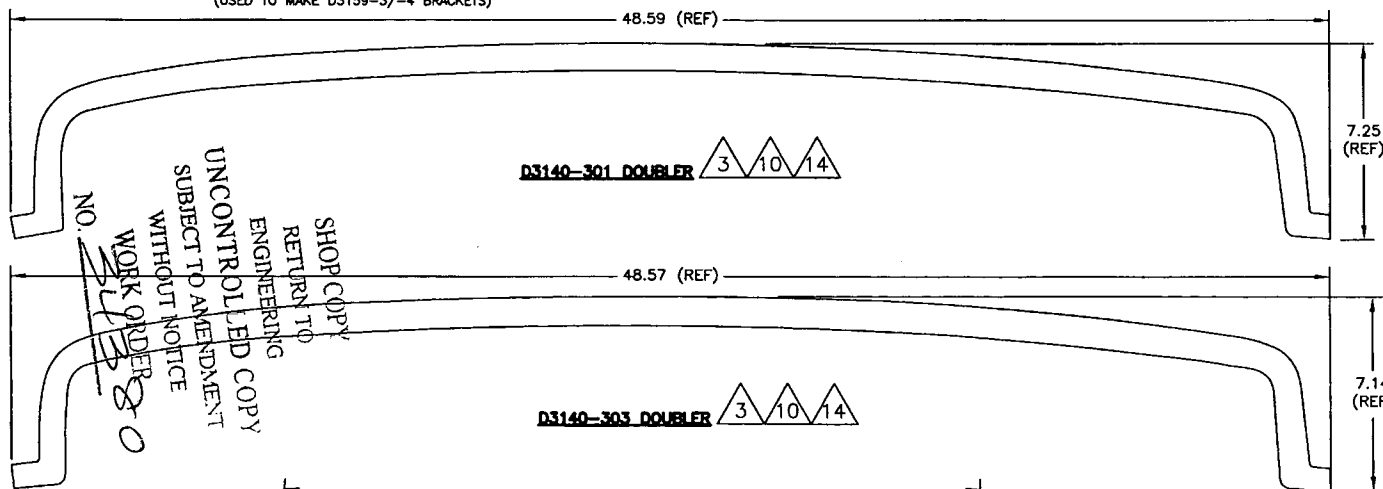


D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



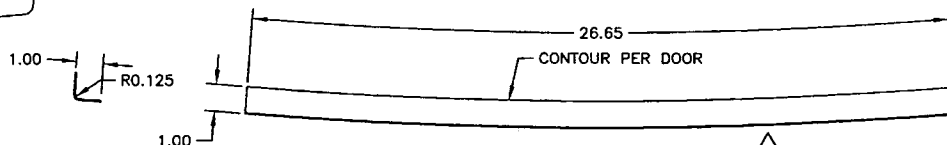
D3140-104 DOUBLER $\triangle 4 \triangle 14 \triangle D \triangle F$
D3140-103 OPPOSITE

D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER $\triangle 3 \triangle 10 \triangle 14$

D3140-303 DOUBLER $\triangle 3 \triangle 10 \triangle 14$



D3140-85 ANGLE $\triangle 6$
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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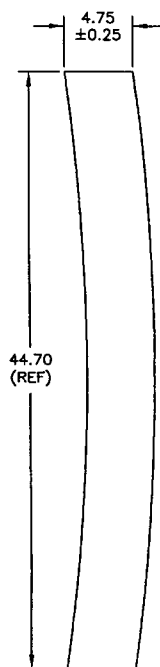
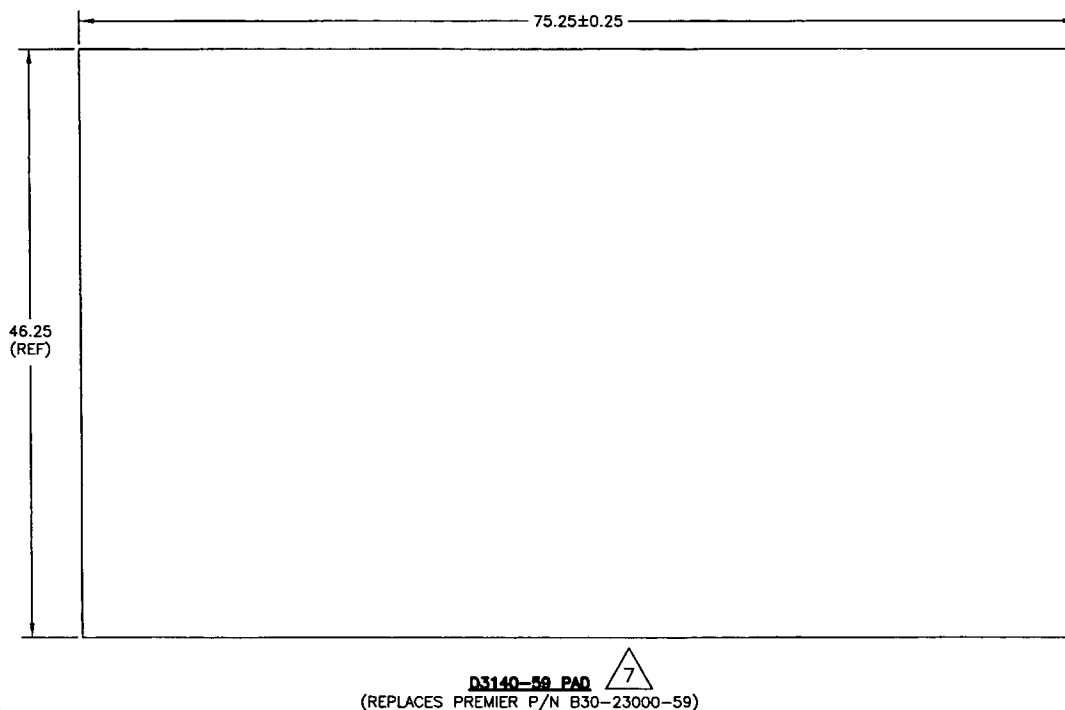
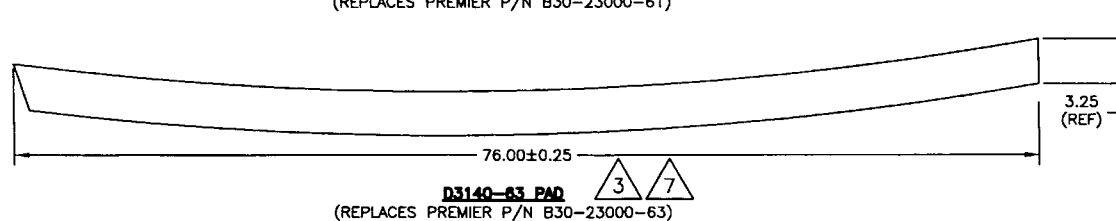
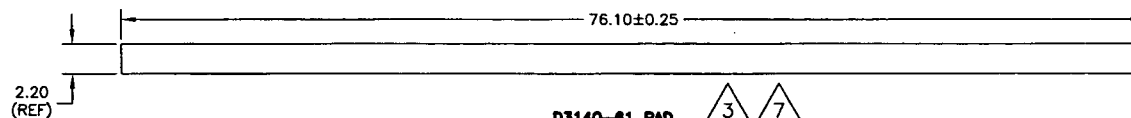
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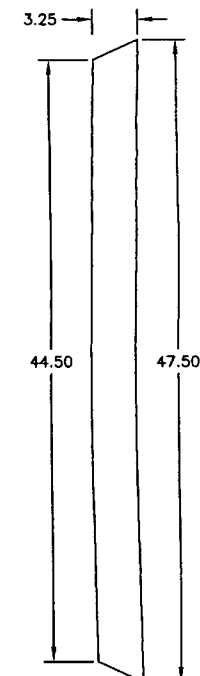
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| CHECKED JH | APPROVED JH | DRAWING NO. D3140 | REV. F SHEET 6 OF 7 |
| DATE 06.10.06 | TITLE DOOR | SCALE NTS | |



D3140-57 PAD
(REPLACES PREMIER
P/N B30-23000-57)

3 7



D3140-241 DOUBLER 5 14
(REPLACES PREMIER P/N B30-23000-241)

RELEASED

06.11.13

R1.00
(2 PLACES, REF)

| | | | | | |
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| | | DATE | | DRAWING NO. | REV. F |
| | | 06.10.06 | | D3140 | SHEET 7 OF 7 |
| | | | | TITLE | SCALE |
| | | | | DOOR | NTS |

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